

Blue

Work Order ID 86562

86562

Page 1

July-05-12 10:34:32 AM

Item ID: D3413-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Ring

Start Date: 7/05/12

Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/20/12

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3413

Rev A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3413

Dwg Rev: A

Prog Rev: A

2- Deburr and drill hole if required as per dwg D3413 & QSI018 4.1 .

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

10 0 Jm 12-7-12

10 0 Jm 12-7-12

304 . 350 X 4"

Work Order ID 86562

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Page 2

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Item Name: Ring

Start Date: 7/05/12

Start Qty: 10.00

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10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS 16 7/9/13

710

155

0.00

155

SprayPaint

Memo

0.00

Spray Painting

PRIME B 117319
Delfleet BLUE B 121149
CLEAR Delfleet B 121703

AB

12-7-15 10

165

QC14- Inspect Spray Paint

0.00

165

QC

Memo

0.00

Quality Control

DAS 16 7/9/16

86562

July-05-12 10:34:32 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

10

10

Reference:

Run Start *NR1*

Stop *NR2*

**Insp.
Stamp**

tion: 8420

0.00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

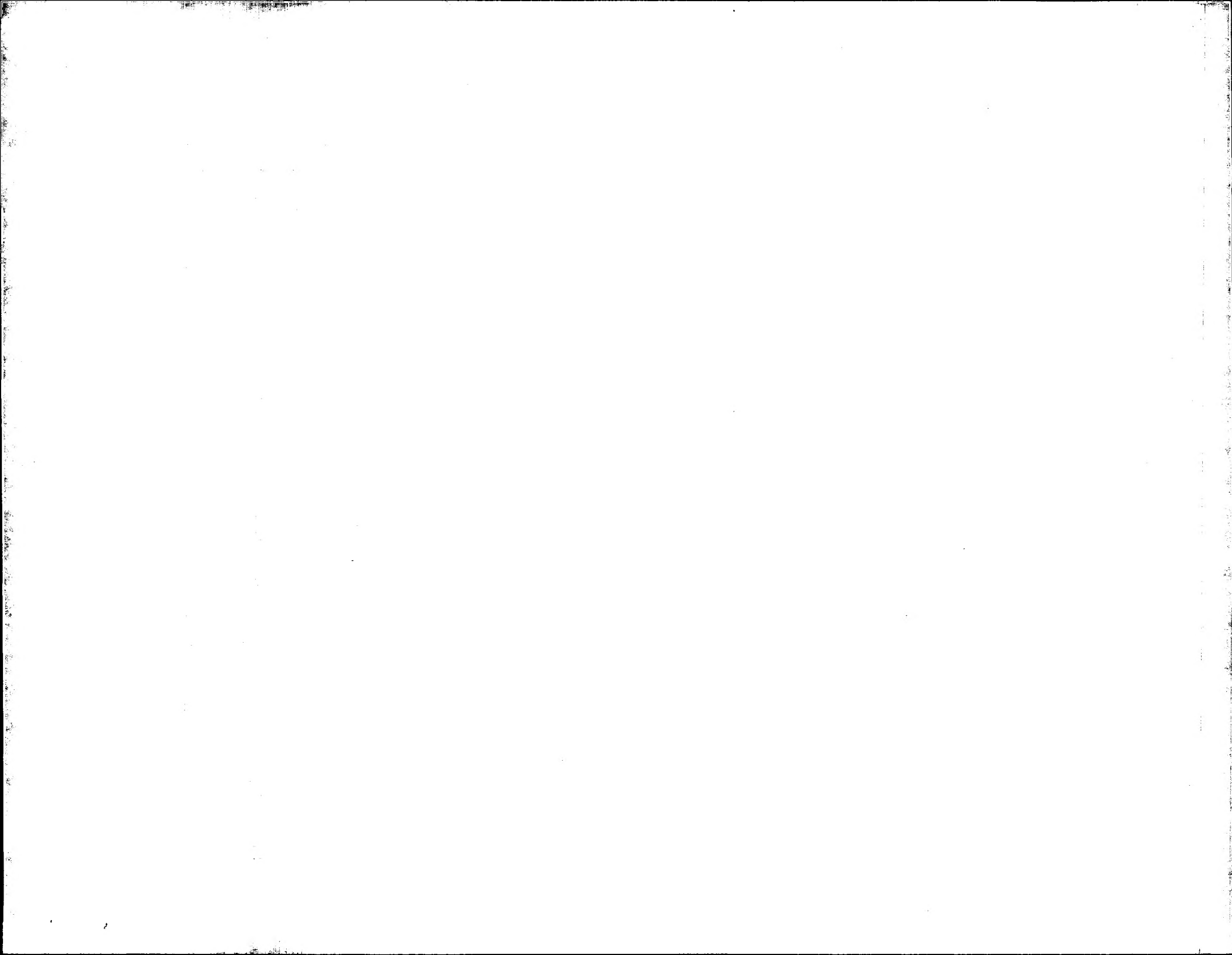
Quality Control

10x

~~SP~~
12-7-16

12/7/18

MF
12-07-16



Picklist Print

July-05-12 10:34:32 AM

Page 1

Work Order ID: 86562

Parent Item: D3413-1

Parent Item Name: Ring

Start Date: 7/05/12

Required Date: 7/20/12

Start Qty: 10.00

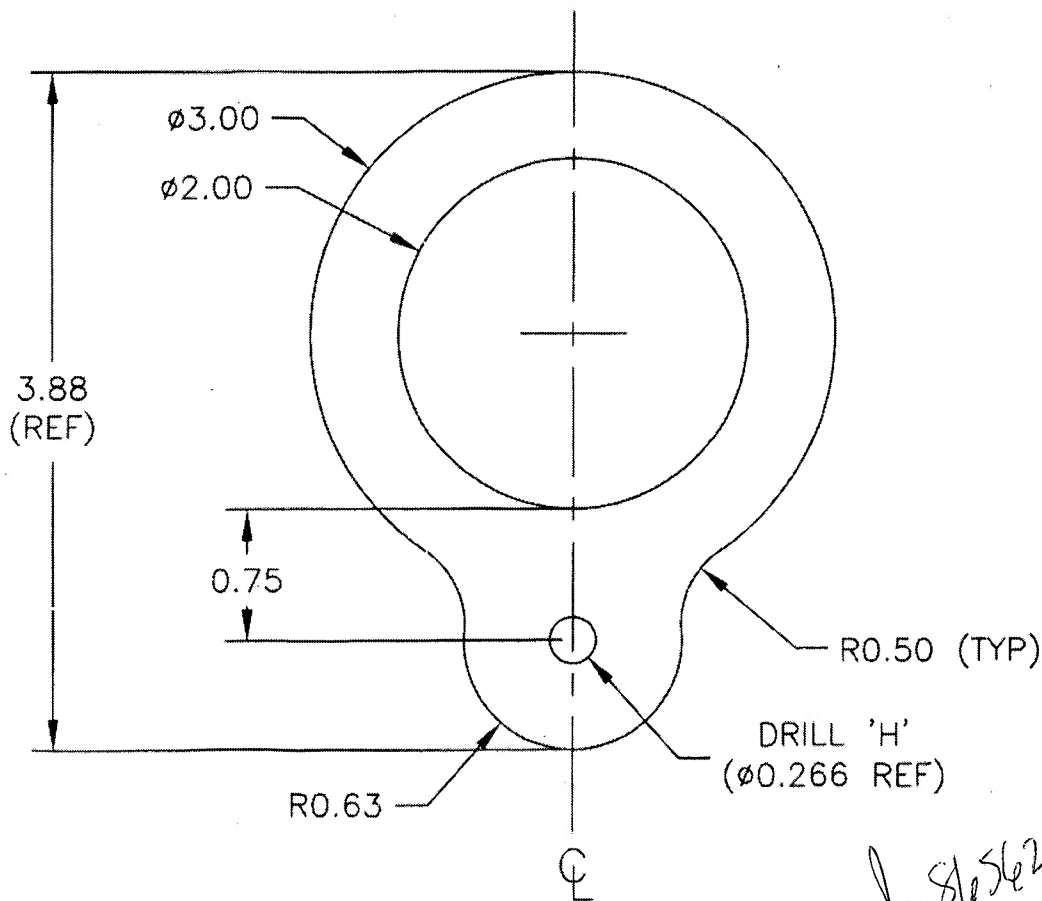
Required Qty: 10.00

Comments: IPP Rev:A05.09.13New issueKJ/JLM
IPP Rev:B Now on Waterjet 07-05-28 JLM

Component Item ID/ Item Name	Replacement item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250X4.000		Purchased	No			100	f	37.7000	0.25	2.6315789			
304 BAR .250 x 4.00										2.7			Jun 12-7-12
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT050		37.7							
				119043		17							
				119766		8.7				119766			
				119840		12							

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3413	REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE RING	SCALE 1:1
A	05.03.16	NEW ISSUE	

RELEASED
05-09-06 *[Signature]***D3413-1 RING**

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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